

Work Order ID 131869

131869

Page 1

Tuesday, April 21, 2015 2:07:59 PM

Item ID: D3393-041 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Battery Lock

Start Date: 4/16/15 Start Qty: 6.00 *6* Cust Item ID:

Required Date: 4/20/15 Req'd Qty: 6.00 *6* Customer:

Reference:

Approvals: Process Plan: MCS Date: 15-04-22 Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3393	Rev A								

100 0.00
100 Small Fab 6 FF JUN 10 2015

Small Fab Memo 0.05

ATTN: - CHECK IF KEYED ALIKE OR KEYED DIFFERENT

1-Open D3373-1 lock package. Keep keys, lock body, lock body nut, flat cam and lock barrel. Discard the rest. 2-Using the flat cam, fabricate D3369-5 as per Dwg D3369 Identify as D3369-53-Assemble D3393-041 as per Dwg D3393. Insert lock body and fasten

LockTite 262: m 125715

110 0.00
110 Large Fab 6 15-06-12

Large Fab Memo 0.03

Tack Weld lock shaft to flat cam of a Max 1/8" Long Qty Part Number

Description Batch A/RN/A SS Rod 128077

DQA: AW Date: 15/07/09



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: AW Date: 15/07/08

Work Order update only

Work Order: <u>B131849</u> Part No. <u>D3393-241</u> NCR No. <u>15-5176</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☒ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☒ Rec/Store/Packaging Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date: <u>15-07-08</u>		Step #: <u>100</u>		QTY Effective: <u>0</u>		MRB (QSI042) Approval DAS 9 15-07-08 9-89	
Description Work Order Deviation				Disposition			
Fabricated 3369-5 as per instructions on Sequence 100. To make fabricate 3369-5 out of a Fat can in Lock Package D3373-1. There is no indication on work order in packing list that I have to pull it from stores. work order was never changed for since 2013. Nothing was done on the work order.				work order as been update D3369-5 was SCRAP due to w/o not calling out Pick in of D3373-1. RC. w/o was not updated correctly since 2013.			
Root Cause Environment ☐ Design ☒ Doc/Data ☒ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☒ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐				Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cut ☐ Set-up ☒ BOM/Route ☒ Broken/Damage/ ☐ Inspection Incom ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐			
OTHER: ☒				Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
120									
QC	Memo	0.00							

Quality Control

130	Small Fab	0.00							
130									
Small Fab	Memo	0.02							
Small Fab	Apply Crazy Glue to cap and press into Body 9567K21								
	Batch: <u>1131492</u>								

140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control									

DAS
38
9-89

JUN 15 2015

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: Date:

Work Order update only

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition					
1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>st 501</u>	0.00				6	27 27		
150									
Packaging	Memo	0.03							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

JUN 16 2015

MLJ JUN 18 2015

u 15-06-17

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

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Work Order ID: 131869

131869

Parent Item: D3393-041

D3393-041

Parent Item Name: Battery Lock

Start Date: 4/16/15

Required Date: 4/20/15

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 05-11-22 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
5/16WC *5/16WC* Washer		Purchased	No			100	Each	158.0000	2	12	**	FF	APR 28 2015
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				st572			158						
				m131961			158						
9567K21 *9567K21* Polyethelene Cap		Purchased	No			100	Each	77.0000	2	12	**	FF	APR 28 2015
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST564			77						
				m129254			77						
D3373-1 *D3373-1* Cam Lock		Manufactured	No			100	Each	21.0000	1	6	**	FF	APR 28 2015
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				GA			7						
				105986			7						
				ST035			14						
				121920			8						
				74862			6						
D3393-1 *D3393-1* Battery Lock Casing		Manufactured	No			100	Each	8.0000	1	6	**	FF	APR 28 2015
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST501			8						
				120136			8						

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Parent Item: D3393-041

D3393-041

Parent Item Name: Battery Lock

Start Date: 4/16/15

Required Date: 4/20/15

Start Qty: 6.00

Required Qty: 6.00

D3393-3

Manufactured No

140

Each

5.0000

1

6

**

FF JUN 10 2015

D3393-3

Cam Lock Shaft

Location

Loc Qty

Loc Code

ST036 B132207 * 5
108529 3
109126 2

3
3

B102513

Batch:

~~B132207~~

3369-5

qty 1

D3373-1 14

5/16 W

--- : B105986

--- : B131961

--- : B102513

B

D3393-3 14

--- : B132207

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Shop Packet Print

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